

ASAP  
Work Order ID 116331

April-10-14 12:38:47 PM

\*116331\*

Page 1

Item ID: D4153-5

Revision ID:

Item Name: Clamp

Start Date: 4/10/14

Start Qty: 12.00

\*12\*

Required Date: 4/11/14

Req'd Qty: 12.00

\*12\*

Reference:

Approvals:

Process Plan: U

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4153

B

0.00

0.00

0.00

0.00

100

\*100\*

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: \_\_\_\_\_

Prog Rev: \_\_\_\_\_

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

110

\*110\*

QC

Quality Control

Memo

12 mm 14/04/10

12 mm 14/04/10

**Work Order ID 116331**

April-10-14 12:38:47 PM

**\*116331\***

Page 2

Item ID: D4153-5

Revision ID:

Item Name: Clamp

Start Date: 4/10/14

Start Qty: 12.00

**\*12\***

Required Date: 4/11/14

Req'd Qty: 12.00

**\*12\***

Reference:

Accept

**\*N9000040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

Quality Control

0.00

130

Identify as per dwg & Stock Location: 5T241A

0.00

**\*130\***

Packaging

Memo

Packaging

0.00

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

Quality Control

0.00

12x DAS  
28  
9-89 APR 11 2014PC 14-04-14W 4104-14

# Picklist Print

April-10-14 12:38:47 PM

Page 1

Work Order ID: 116331

**\*116331\***

Parent Item: D4153-5

**\*D4153-5\***

Parent Item Name: Clamp

Start Date: 4/10/14

Required Date: 4/11/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 11.09.26 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

413.9600

0.243

4

**\*M304S18GA\***

**\*\***

*mm/14/04/10*

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT019

401.96

117188

3

117766

5

120604

5

122325

3

123155

3

124572

38

M126647

39.75

M128254

117.96

M128435

187.25

MAT020

12

124029

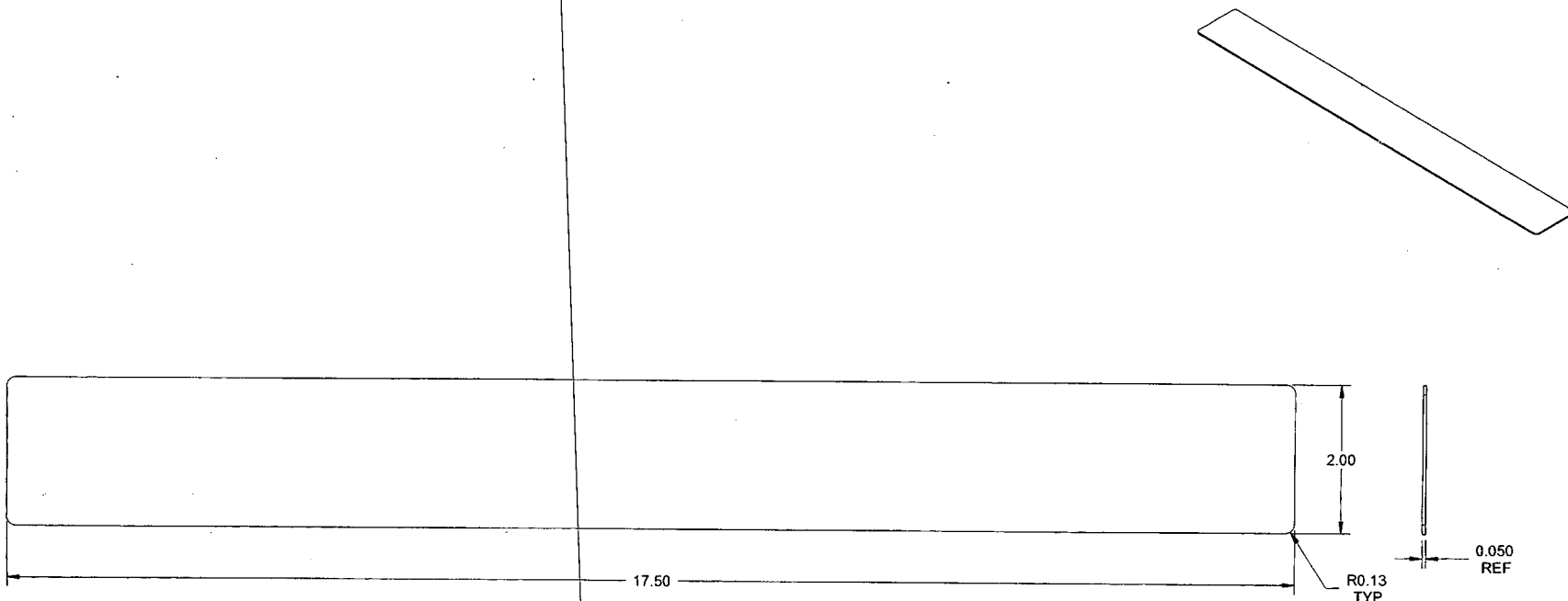
2

M126098

10

4.





**D4153-5 CLAMP PLATE**



*W/B 116391*

**RELEASED**  
2011-09-21

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 18 GAUGE (0.050 THICK)  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.50 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D4153	SHEET 5 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	<b>JOGGLE BRACKET</b>	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	